

Work Order ID 86442

June-28-12 1:04:54 PM

86442

Page 1

Item ID: D2877

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Saddle Spacer

Stop ***NS2***

Start Date: 28/06/2012 Start Qty: 40.00

40

Cust Item ID:

Required Date: 12/07/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/12

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2877	Rev B
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100	FLOW WATER JET	0.00
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100

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2877 Dwg Rev: B Prog Rev: B 2-deburr

6061 .125"

40 0 Jm 12-7-7

110	QC2- Inspect parts off machine FAI/FAIB	0.00
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110

QC

Memo

0.00

Quality Control

40 0 Jm 12-7-7

120	QC8- Inspect parts - second check	0.00
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120

QC

Memo

0.00

Quality Control

5-16/10

counts
740

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Deburr if necessary								
140		0.00							
140	Chemical Conversion Coat per QSI005 4.1								
HandFinish	Memo	0.00							
Hand Finishing									
150		0.00							
150	QC3- Inspect Part Finish								
QC	Memo	0.00							
Quality Control									

40 161279

40 161279

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40

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location 20

0.00

160

Packaging

Memo

0.00

Packaging

400 12/7/10 54

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

OK 12/7/11
ME
12-07-10

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Picklist Print

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Page 1

Work Order ID: 86442

86442

Parent Item: D2877

D2877

Parent Item Name: Saddle Spacer

Start Date: 28/06/2012

Required Date: 12/07/2012

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP B 00.05.19 Added inspect level 8EC
IPP C 06.04.26 Water jet EC
IPP Rev:D Now M6061-T6 06-06-23 JLM
IPP Rev:E Updated Thickness as per Rev B 06-09-18 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location
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M6061T6S.125

Purchased

No

M6061T6S 125

6061-T6 .125 Sheet

Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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110

sf

33.4576

0.0607

2.555789

**

2.6 SF.

Sm. 12-7-7

Location

MAT021

121473

Loc Qty

33.4575526

33.4575526

Loc Code

121473

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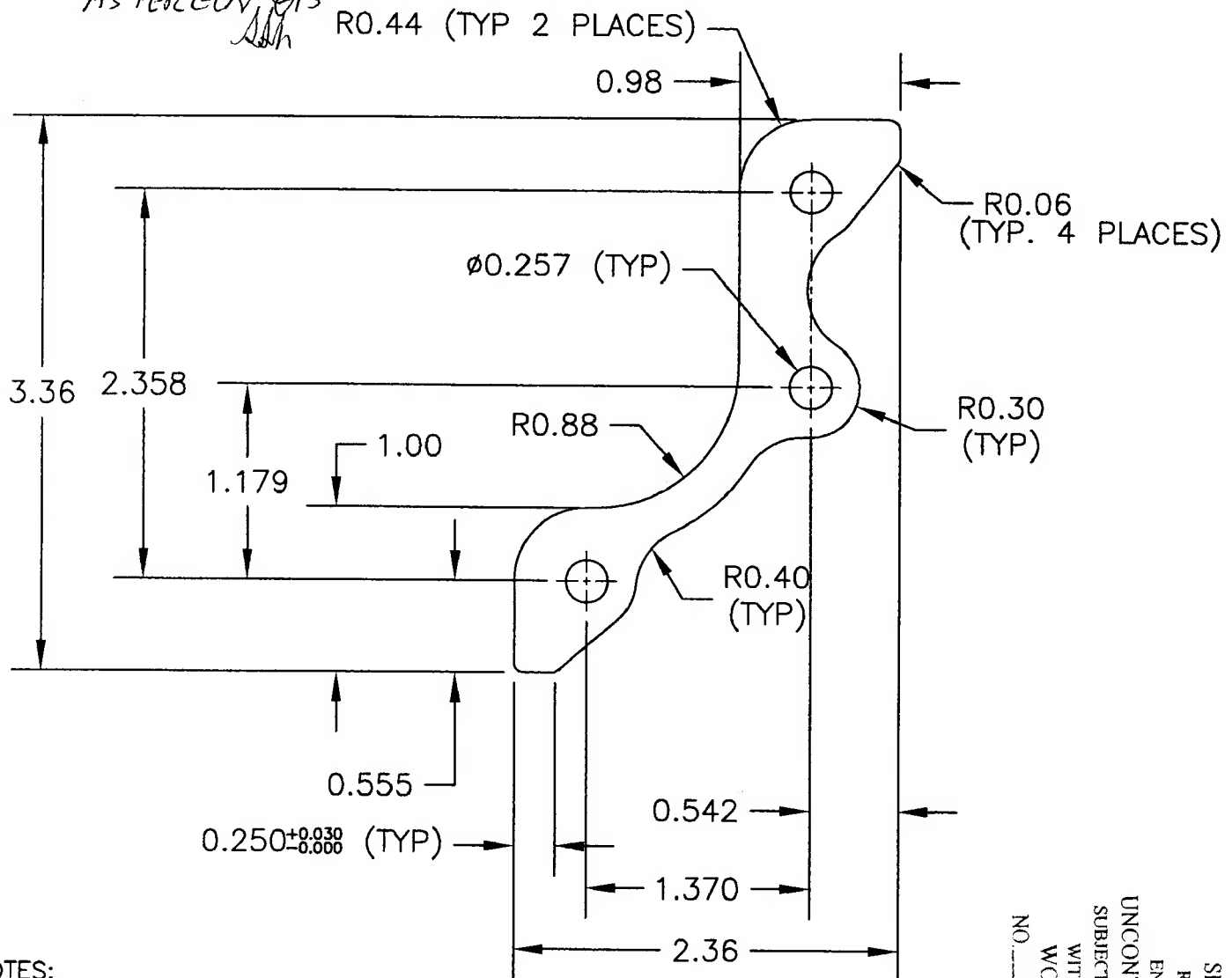
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DART

DESIGN <i>CP</i>	DRAWN BY <i>C.B.</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2877	REV. B SHEET 1 OF 1
DATE 06.05.17	TITLE SADDLE SPACER SCALE 1:1		
A	99.02.23	NEW ISSUE	
B	06.05.17	THICKNESS WAS 0.100", MAT CHANGE	

RELEASED
*06.06.21.**AS PER ECN 813*
[Signature]**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET (QQ-A-250/11) 0.125" THICK (REF DART SPEC M6061T6S.125) OR 5052-H32/H34 ALUMINUM SHEET (QQ-A-250/8) 0.125" THICK (REF DART SPEC M5052H32S.125)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *065412* *MCS*
12/06/28

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